



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBF5450-501-1
Job Sheet 173229



Part No: RBF5450-501-1

Job Qty: 5 ea

Part Name: F Model Clutch Removal Tool-New Design



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBF5450-501-1 REV:3 IPP REV A 18.02.22 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		2/15/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	5 pcs		2/16/18	0.05	0.25	Small Fab-9		MCC
110	QC	5 pcs		2/16/18	0.00	0.00	QC5		38
130	Packaging	5 pcs		2/16/18	0.00	0.00	Packaging3-2		18-28-16 GA 156 RB
140	QC21-FG	5 Ea		2/16/18	0.00	0.00	QC21		21

Part Op 100 - Assemble

Descriptions: 130 - Identify and Stock

MAY 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBF5450-501-1-20	"F" Model Clutch Extension	5 Ea (1 ea)	90-Start up Operation	5071057
RBF5450-501-1-30	3/8 Long Hex Bit Socket	5 Ea (1 ea)	90-Start up Operation	5071068
98296A849	TBD	5 (1 ea)	100-Small Fab	5048587
RBF5450-501-1-10	Handle Weldment	5 Ea (1 ea)	100-Small Fab	5064976

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBF5450-501-1-20	5	0	0
	RBF5450-501-1-30	5	0	0
100-Small Fab	98296A849 41	5	0	0
	RBF5450-501-1-10 157	5	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

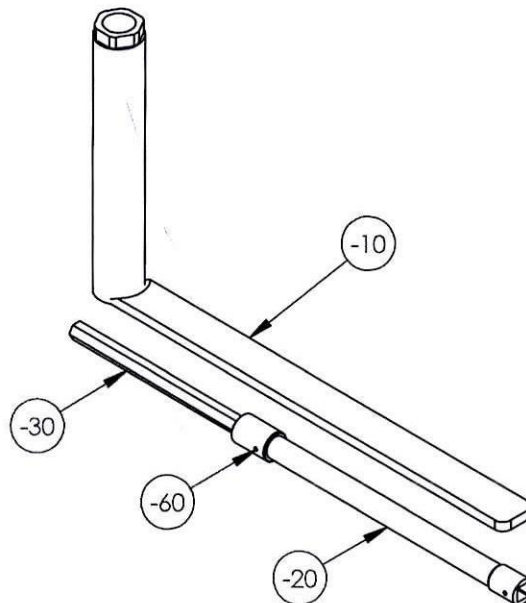
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Ther	AGAINST DEPARTMENT/PROCESS Water Jet ☐ Engineering ☐ Quality ☐ Other ☐																																																				
Date : _____ Step #: _____																																																							
Description Work Order Deviation			(QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																				
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-50 ADDED OVERALL DIM. CH'D TEXT.	4/24/2009	RJC	RW
2		-30 ADDED REFERENCE DIM Ø.705. -50 CH'D I.D. FROM .718.	6/23/2011	RJC	RW
3	15-0310	-10 ADDED WELDMENT. -20 CORRECTED B/O INFO WAS PROTO #J5261 IS PROTO #J5261 (MSC #85214161) MODIFIED. -30 CORRECTED B/O INFO WAS PROTO #J4990 3/8XL (MSC #84967330) MODIFIED. -40 CH'D MATERIAL CALLOUT WAS 1018 IS 1018/1020, CH'D TITLEBLOCK TOLERANCE. -60 ADDED B/O P/N MCMASTER-CARR #98296A849.	9/24/2015	RJC	JAG



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 173229 MJS
18-02-27

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-10	1	HANDLE WELDMENT			2
			-20	1	EXTENSION	STEEL	3/8dr. X 8 PROTO #J5261 (MSC #85214161) MODIFIED	3
			-30	1	LONG HEX BIT SOCKET	STEEL	3/8dr. 3/8 X 6-3/32 PROTO #J4990 3/8XL (MSC #84967330) MODIFIED	4
	1		-40		HANDLE	1018/1020		5
	1		-50		TUBE	CDS OR DOM		6
		B/O	-60	1	ROLL PIN	STEEL	Ø3/32 X 5/8 (MCMASTER-CARR #98296A849)	1
	ASSY -10							

DART AEROSPACE	
TITLE CLUTCH REMOVAL TOOL	
DWG NO. RBF5450-501-1	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: COLE APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL MD 369
SCALE 1:4	DATE 9/1/2000 SHEET 1 OF 6

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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